

Order 8046

me

1 Oct



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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August

D3883-2
Job Sheet 182459



Part No: D3883-2

Job Qty: 10 ea

Part Name: Saddle, Outside RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/21/18	0.00	0.00	Start Up Machining-2		SBL/11/8
100	CNC Vertical Machining	10 pcs		9/21/18	0.64	22.73	HAAS1-5		SBL/11/8
110	QC	10 pcs		9/21/18	0.00	0.00	QC2 Machining-2		SBL/11/8
120	QC	10 pcs		9/21/18	0.00	0.00	QC8 Machining-2		SBL/11/8
130	HandFinish	10 pcs		9/21/18	0.00	1.02	HandFinish1		SBL/11/8
140	Powdercoat	10 pcs		9/21/18	0.00	0.38	Powdercoat1		SBL/11/8
150	QC	10 pcs		9/21/18	0.00	0.00	QC3		SBL/11/8
160	Packaging	10 pcs		9/21/18	0.00	0.00	Packaging3-2		SBL/11/8
170	QC21-SA	10 Ea		9/21/18	0.00	0.00	QC21		SBL/11/8

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Last
page

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA817
and inspect per Dimension Sheets
110 - Inspect on CMM as per folio CMM013.
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M/138951 START: 10:20 O.D.T. 220° FINISH: 10:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-015	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	6X5110300 2X5111639

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-015	10	8	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 182459
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.643	0.643	0.644	0.644		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.610	0.611	0.612	0.611		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.145	0.149	0.148	0.150		
K	0.240	0.260		0.244	0.249	0.248	0.248		
L	0.115	0.135		0.127	0.127	0.127	0.127		
M	0.140	0.165		0.145	0.149	0.149	0.150		
N	0.720	0.780		0.755	0.760	0.760	0.760		
O	0.240	0.260		0.251	0.255	0.250	0.250		
P	0.110	0.140		0.140	0.137	0.137	0.135		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.860	2.856	2.856	2.855		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		0.995	0.996	0.995	1.00		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.001		
W	1.245	1.255		1.25	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.499	0.500	0.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.030	0.030	0.030	0.038		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.217	0.217	0.217	0.217		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: DAS	Audited by: mmc
Date: 57	Date: 8/11/08
9-09 18/11/01	

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order:	182459
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.648	0.639	0.647	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.615	0.606	0.615	0.617		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		0.148	0.148	0.148	0.148		
K	0.240	0.260		0.246	0.246	0.248	0.250		
L	0.115	0.135		0.127	0.126	0.126	0.127		
M	0.140	0.165		0.150	0.150	0.148	0.148		
N	0.720	0.780		0.700	0.760	0.76	0.760		
O	0.240	0.260		0.251	0.251	0.254	0.252		
P	0.110	0.140		0.137	0.137	0.140	0.137		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.857	2.856	2.856	2.856		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.000	1.002	1.005	1.005		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010	6.001	6.001	6.001	6.001	6.001		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.500	0.4985	0.500	0.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.313	0.313	0.313	0.313		
AB	0.020	0.040		0.030	0.030	0.030	0.030		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.219	0.218	0.218	0.218		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject									

Measured by: DAS	Audited by: m p m
Date: 57 18/11/02	Date: 18/11/02
9-89	

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 182459
Description: Saddle, Outboard, RH		Part Number: D3883-2
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	3	4	By	Date
A	2.870	2.880 ✓		2.875	2.875				
B	1.433	1.443 ✓		1.438	1.438				
C	0.638	0.658		0.647					
D	3.895	3.905 ✓		3.900	3.900				
E	0.257	0.262 ✓		0.257	0.257				
F	0.605	0.625		0.615	0.615				
G	1.120	1.130 ✓		1.125	1.125				
H	2.245	2.255 ✓		2.250	2.250				
I	2.000	2.020 ✓		2.000	2.000				
J	0.140	0.165		0.150	0.150				
K	0.240	0.260		0.250	0.25				
L	0.115	0.135		0.127	0.127				
M	0.140	0.165		0.150	0.150				
N	0.720	0.780 ✓		0.750	0.750				
O	0.240	0.260		0.254	0.252				
P	0.110	0.140		0.140	0.140				
Q	0.178	0.198 ✓		0.188	0.188				
R	2.825	2.885 ✓		2.856	2.856				
S	0.316	0.321 ✓		0.316	0.316				
T	0.990	1.010		1.003	1.001				
U	1.745	1.755 ✓		1.750	1.750				
V	5.990	6.010		6.001	6.001				
W	1.245	1.255 ✓		1.250	1.250				
X	0.490	0.510		0.501	0.500				
Y	1.220	1.280 ✓		1.250	1.250				
Z	2.495	2.505 ✓		2.500	2.500				
AA	0.313	0.318 ✓		0.313	0.313				
AB	0.020	0.040		0.030	0.030				
AC	0.760	0.765 ✓		0.760	0.760				
AD	0.215	0.220		0.218	0.218				
AE	1.265	1.285 ✓		1.265	1.265				
AF									
Accept/Reject									

Measured by: DAS	Audited by: <i>mgc</i>
Date: 57 0-89 18/11/02	Date: 18/11/02

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

How many?

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 82459		AGAINST DEPARTMENT/PROCESS	
Part No. D38832		Water Jet	
NCR No. 19-7144		Engineering	
Date: 18/11/9		Quality	
Step #: 100		Other	
Description Work Order Deviation		MRB (Q51042) Approval	
Part was not correctly installed on the jig		DAS 9 18.11.05	
Disposition		Completed By	
replace and scrap		UAF 18.11.05	
Root Cause		Lead hand / Supervisor	
No Re-verification		Approval Verification	
Operator		DAS 9 18.11.05	
Offset/Setup		QC / QA Coordinator	
Supplier		Approval	
Training		Positioned Wrong	
Use for Testing		Outside Dimensions	
Poor Information		Over/Under tolerance	
Rushing		Part Incorrect	
Product Improvement		Part Lost/Missing	
Process Improvement		Part Moved	
Manufacturing Process		Drawing	
Past Due		Finish	
Environment		Misread	
Design		Turning Sequence	
Doc/Data		Power Loss/Surge	
Equip/Tooling		Folio/Program	
Handling/Pre		Grain	
Material		Weld	
Internal Transport		Wrong Stock Pulled	
Tribal Knowledge		Out of Sequence	
LOA		Off-set	
Substation		Mislabeled	
Past Expiry Date		Fit/Function	
Misidentified		Misaligned/off center	
Pressure/Forced		Temperature/Cure	
Bending		Set-up	
Centre Not Concentric		BOM/Route	
Cracks		Broken/Damage/Defect	
Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	
Cuffs		Contamination	
Crushing		Countersink	
Heat Treat		Cut Too Short	
Wave/Twist in Tube		Instructions Incomplete/Unclear	
Marks/Chatter		Drill Holes	
OTHER :			

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I